

the casting in the case of the jig shown in Fig. 61, while in Fig. 62 the binding screw is removed from the clamp. The clamp shown in Fig. 62 has been cut away at *B* to permit the point of the screw to clear it; a spring-pin holds the clamp against the screw at all times.

Fig. 63 shows a hinged cover with the clamp attached to it. This is a convenient arrangement to remember when considering the design of jigs and fixtures. The clamp and cover are

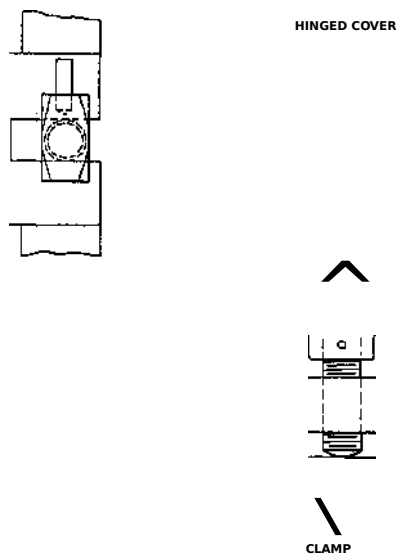


Fig. 63. Hinged Cover with Attached Clamp

held by the same pin and both parts are swung out of the way at the same time by means of the corner of the clamp, which catches on the hinged cover at *B*. The design is such that the fixture has sufficient clamping range when the cover is held in place by the screw *C*. The clamping is effected by means

of the screw in the cover which forces the clamp down on the work. Fig. 64 shows a clamp beveled at the end to pull the work down flush and push it into the V at the same time. The clamp is tightened by a screw and a spring forces it open when